

Work Order ID 154216

Tuesday, December 06, 2016 2:50:45 PM

154216

Page 1

Item ID: D2587

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Door Plug

Start Date: 12/2/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 12/6/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date: DEC 07 2016

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2587	Rev A1							DAS 46 9-89	16/12/12
100		0.00							
100	FLOW WATER JET								
Waterjet	Memo	0.03							
FLOW CNC Waterjet	1-Cut as per Dwg D2587 Dwg Rev: <u>A1</u> Prog Rev: <u>A1</u> 2- Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00						DAS 46 9-89	16/12/12
110									
QC	Memo	0.02							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.03							
Quality Control									

DAS
38
9-89
DEC 12 2016

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00				(X10)	X		2016/12/12
130	HandFinish	Memo							BE
Hand Finishing		0.03							
140	QC3- Inspect Part Finish	0.00				10			DAS 38 9-89
140	QC	Memo							DEC 15 2016
Quality Control		0.02							
150	Identify as per dwg & Stock Location: <u>Stock</u>	0.00				10			DAS 6 9-89
150	Packaging	Memo						DEC 19 2016	
Packaging		0.02							

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NS1

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Stop

NS?

Item Name: Door Plug

Start Date: 12/2/2016 **Start Qty:** 10.00

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Cust Item ID:

Required Date: 12/6/2016 **Req'd Qty:** 10.00

10

Customer:

Reference:

Run Start

NR1

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

NR2

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject Qty

Reject
Number

**Insp.
Stamp**

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.17

Quality Control

**DAS
21
9-89**

DEC 19 2016

MF
16-12-19

Picklist Print

Tuesday, December 06, 2016 2:50:45 PM

Page 1

Work Order ID: 154216

154216

Parent Item: D2587

D2587

Parent Item Name: Door Plug

Start Date: 12/2/2016

Required Date: 12/6/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP D04.05.31 Step 2 changed KJ/JLM
IPP E06.07.31 Waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.040

Purchased

No

100

sf

272.8100

0.016

0.168421

DAS
46
9-89

**

16/12/12

M6061T6S 040

6061-T6 .040 Sheet

Location

Loc Qty

Loc Code

MAT021

272.81

m135147

0.92

m135612

38.27

m135632

84.78

m135724

148.84

0.2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

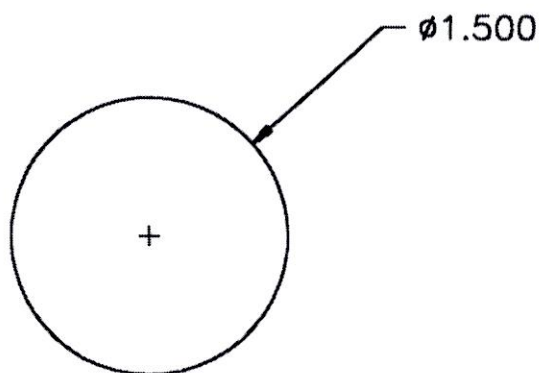
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																											
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			Lead hand / Supervisor Approval Verification																																																																												
			QC / QA Coordinator Approval																																																																												
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DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
MIKE M	B WILLIAMS	DRAWING NO.	REV. A
CHECKED <i>M. M.</i>	APPROVED <i>M. M.</i>	D2587	SHEET 1 OF 1
DATE	TITLE		SCALE
96:07:11	DOOR SLUG		1:1
AI <i>[initials]</i> 03.09.16		ADD 6061-T6 OPTION	

RELEASED
9607/23 BU



SHOP COPY
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WORK ORDER
NO. 154216 MJS
/6-12-07

OR 6061-T6 (QQ-A-200/B OR QQ-A-225/B) 
MATERIAL: 5052-H32, 0.040 THICK
FINISH: ACID ECTCH, ALODINE